

76285

Tuesday, November 08, 2011 1:32:15 PM

N900040100

Setup Start *NS1*

Stop *NS2*

4

4

Reference:

Run Start *NR1*

Date: 11/11/08

Date:

Stop *NR2*

QC:

Date:

SPC (Y/N):

Date:[illegible]

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 76285***76285***

Page 2

Tuesday, November 08, 2011 1:32:15 PM

Item ID: D3909-041

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Crosstube Lug Assembly, Fwd

Start Date: 11/8/2011 Start Qty: 4.00

4

Cust Item ID:

Required Date: 11/22/2011 Req'd Qty: 4.00

4

Customer:

Reference:

Run Start

NR1

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Stop

NR2

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Identify as per dwg & Stock Location: 471

0.00

130

Packaging

Memo

0.00

Packaging

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

Comp 2/0711/12/07ME
11-1207

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Picklist Print

Page 1

Tuesday, November 08, 2011 1:32:21 PM

Work Order ID: 76285

76285

Parent Item: D3909-041

D3909-041

Parent Item Name: Crosstube Lug Assembly, Fwd

Start Date: 11/8/2011

Required Date: 11/22/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP RevA: New issue DD verified by:EC
per dwg revB DD 10.04.20 verified by:EC

IPP Rev:B as

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2690-6 *D2690-6* Lanyard Assembly		Manufactured	No			100	Each	28.0000	1	4			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST020				28					
				73324				8					
				74515				20					
D3909-1 *D3909-1* Lug Plate, Fwd Crosstube		Manufactured	No			100	Each	7.0000	2	8			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST090				7					
				73429				7					
D3909-3 *D3909-3* Fwd Lower Attach Arm		Manufactured	No			100	Each	12.0000	1	4			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST090				12					
				57819				1					
				65628				1					
				73453				10					
D3909-5 *D3909-5* Eyebolt Stud		Manufactured	No			100	Each	6.0000	1	4			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST091				6					
				73472				6					

**

**

**

**

Handwritten notes and signatures:

- Signature: *[Signature]* 11/12/06
- Signature: *[Signature]* 11/12/06
- Signature: *[Signature]* 11/12/06
- Signature: *[Signature]* 11/12/06
- Text: B 77010 (14)
- Text: 1/2
- Text: 4

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

Page 2

Tuesday, November 08, 2011 1:32:21 PM

Work Order ID: 76285

76285

Parent Item: D3909-041

D3909-041

Parent Item Name: Crosstube Lug Assembly, Fwd

Start Date: 11/8/2011

Required Date: 11/22/2011

Start Qty: 4.00

Required Qty: 4.00

D3910-1 Manufactured No

100

Each

28.0000

2

8

**

~~D3910-1~~
D3910-1
Crosstube Lug

Location

Loc Qty

Loc Code

ENG

2

70160

2

st507

26

73527

26

D3917-1 Manufactured No

100

Each

9.0000

2

8

**

D3917-1
D3917-1
Washer

Location

Loc Qty

Loc Code

ST

9

72710

9

AN3C12A Purchased No

100

Each

108.0000

4

16

**

AN3C12A
AN3C12A
Bolts

Location

Loc Qty

Loc Code

ST351

108

117514

4

118112

5

118422

17

118451

22

118838

10

119510

50

AN3C13 Purchased No

100

Each

38.0000

1

4

**

AN3C13
AN3C13
Bolt

Location

Loc Qty

Loc Code

ST351

38

114714

38

Tuesday, November 08, 2011 1:32:21 PM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Work Order ID: 76285

76285

Parent Item: D3909-041

D3909-041

Parent Item Name: Crosstube Lug Assembly, Fwd

Start Date: 11/8/2011

Required Date: 11/22/2011

Start Qty: 4.00

Required Qty: 4.00

MS17984-C413

Purchased

No

100

Each

11.0000

1

4

**

MS17984-C413

PIN, QUICK RELEASE

Location

Loc Qty

Loc Code

ST315

11

114340

1

118612

2

119307

8

100

Each

114.0000

3

12

**

MS20615-4M20

Purchased

No

MS20615-4M20

RIVET

Location

Loc Qty

Loc Code

GA

114

117071

30

118571

34

119546

50

100

Each

36.0000

1

4

**

AN310C3

Purchased

No

AN310C3

Castellated Nut

Location

Loc Qty

Loc Code

ST349

36

114714

36

EB 11/12/06
M119623 (4X)

EB 11/12/06
M118077 (2X)

EB 11/12/06
if

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Parent Item: D3909-041

D3909-041

Parent Item Name: Crosstube Lug Assembly, Fwd

Start Date: 11/8/2011

Required Date: 11/22/2011

Start Qty: 4.00

Required Qty: 4.00

MS21043-3

Purchased

No

100

Each

727.0000

4

16

MS21043-3

Nut

**

EP 11/12/06

Location

Loc Qty

Loc Code

FG

72

103691

72

ST301

655

118077

1

118614

477

118686

177

16

MS24665-151

Purchased

No

100

Each

374.0000

1

4

MS24665-151

Cotter Pin

**

EP 11/12/06

Location

Loc Qty

Loc Code

ST309

374

17566

374

4

NAS1149C0332R

Purchased

No

100

Each

2,352.000

8

32

NAS1149C0332R

Washer

**

EP 11/12/06

Location

Loc Qty

Loc Code

FP-B

7

117291

7

ST297

2345

116304

55

117460

18

117887

169

118078

2

118179

78

118354

1283

119124

740

32

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Page 5

Tuesday, November 08, 2011 1:32:21 PM

Work Order ID: 76285

76285

Parent Item: D3909-041

D3909-041

Parent Item Name: Crosstube Lug Assembly, Fwd

Start Date: 11/8/2011

Required Date: 11/22/2011

Start Qty: 4.00

Required Qty: 4.00

NAS1149C0363R

Purchased

No

100

Each

3,899.000

2

8

NAS1149C0363R

**

Washer

Location

Loc Qty

Loc Code

ST297

3899

114742

3899

EB 11/12/06
8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

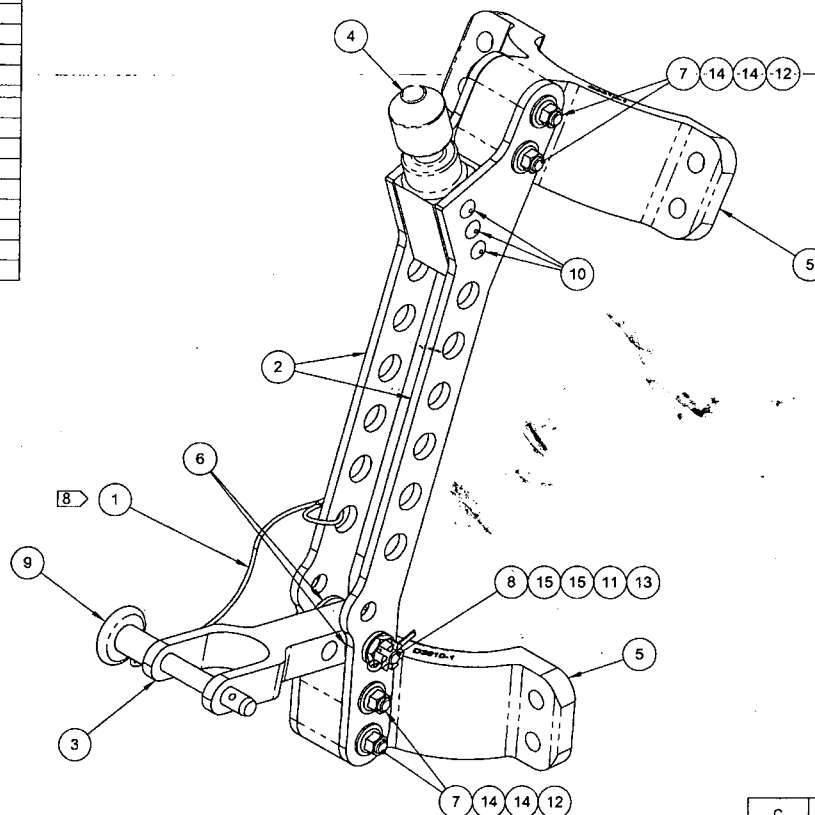
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NOTE: Date & initial all entries

ITEM	QTY -041	P/N	DESCRIPTION
	X	D3909-041	FWD X-TUBE LUG ASSY
1	1	D2690-6	LANYARD
2	2	D3909-1	FWD X-TUBE LUG PLATE
3	1	D3909-3	FWD LOWER ATTACH ARM
4	1	D3909-5	EYEBOLT STUD
5	2	D3910-1	X-TUBE LUG
6	2	D3917-1	WASHER
7	4	AN3C12A	BOLT
8	1	AN3C13	BOLT
9	1	MS17984-C413	PIP PIN
10	3	MS20615-4M20	RIVET
11	1	AN310C3	NUT - CASTELLATED
12	4	MS21043-3	NUT
13	1	MS24665-151	COTTER PIN
14	8	NAS1149C0332R	WASHER
15	2	NAS1149C0363R	WASHER



D3909-041 FWD X-TUBE LUG ASSY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3909-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 1.81 lbs
- 8) ATTACH D2690-6 TO D3909-1 BY LOOPING AROUND LIGHTENING HOLE FIRST AND THEN SECURE TO MS17984-C413 PIP PIN'S RING

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT

WITHOUT NOTICE
WORK ORDER
NO. 76285 M.L.J

11/11/00

RELEASED
2010-08-04

C	ITEM #4: 1.50 WAS 1.30 (ZN B5-5), 2.88 WAS 2.68 (ZN B6-5); WEIGHT AFFECTED (D3909-041-5).	MB.	10.06.18
B	BOM: ADDED ITEM 15 QTY 2 NAS1149C0363R ADDED, ITEM 14 QTY 8 WAS 10. SHT 5, D3909-5 REVISED: SECTION A-A & DIM Ø0.650 REMOVED. SIDE VIEW ADDED. DIM: 2.68 WAS 2.38 REF. 1.30 WAS 1.00, 0.250 WAS 0.220, R0.06 WAS R0.05. WEIGHT REVISED.	JPH	10.04.06
A	NEW ISSUE	JPH	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	JPH		
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.06.18		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3909** REV. C
SHEET 1 OF 5
TITLE **FWD X-TUBE LUG ASSY** SCALE NTS

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

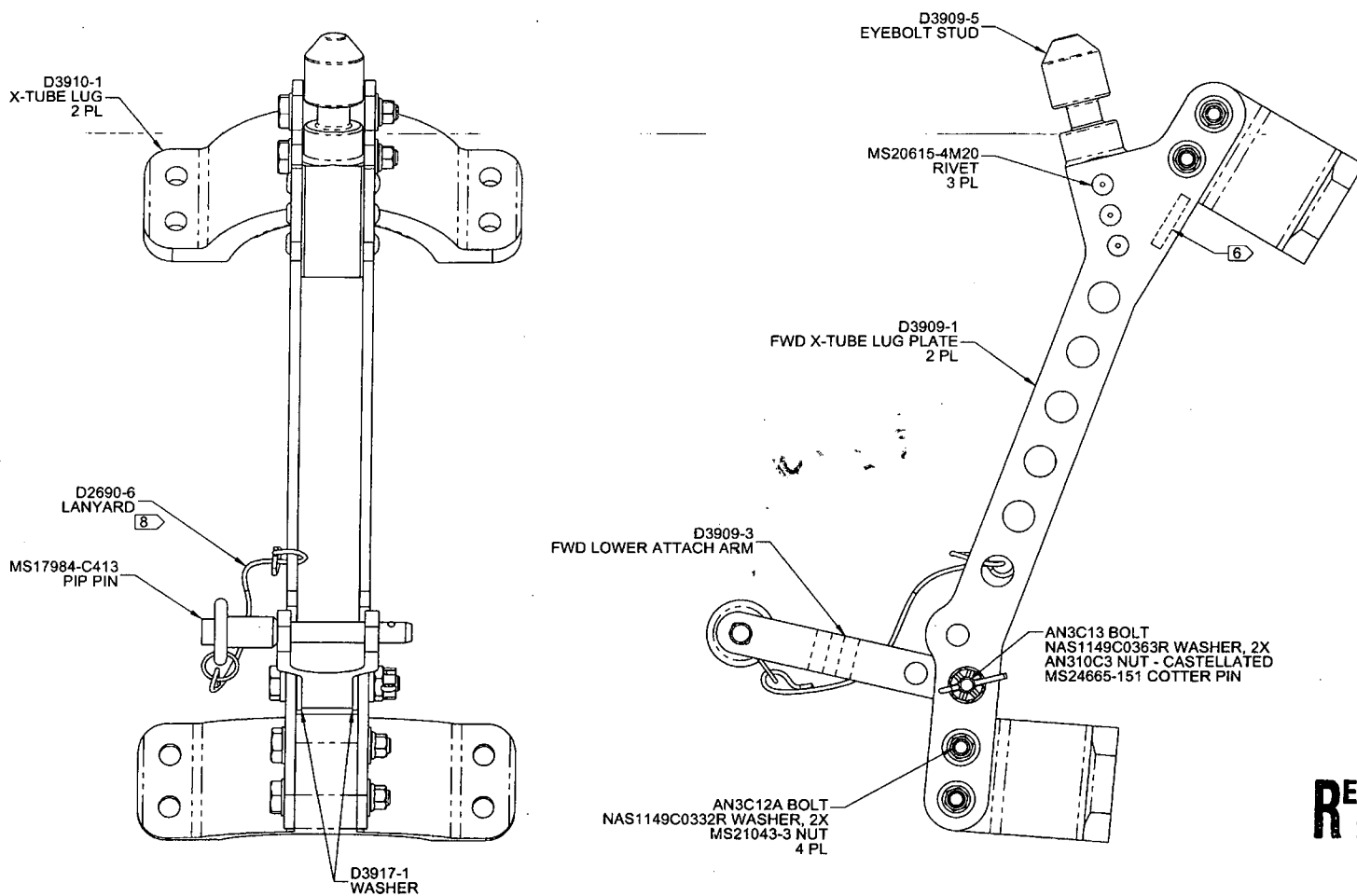
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

76285



D3909-041 FWD X-TUBE LUG ASSY

RELEASED
2010-08-04

DESIGN	JPH	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JPH	DRAWING NO.	REV. C
MFG. APPR.	JPH	D3909	SHEET 2 OF 5
APPROVED	JPH	TITLE	SCALE
DE APPR.	JPH	FWD X-TUBE LUG ASSY	NTS
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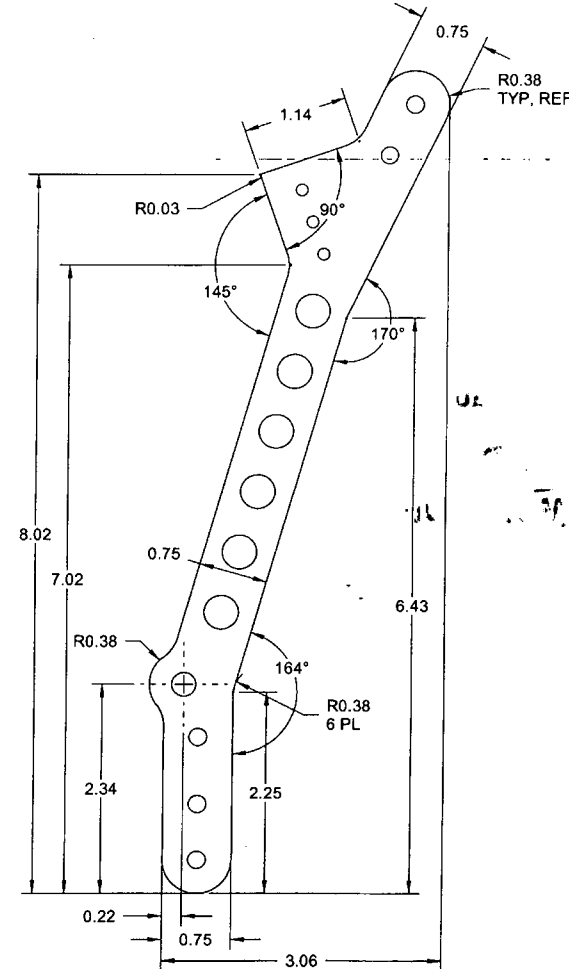
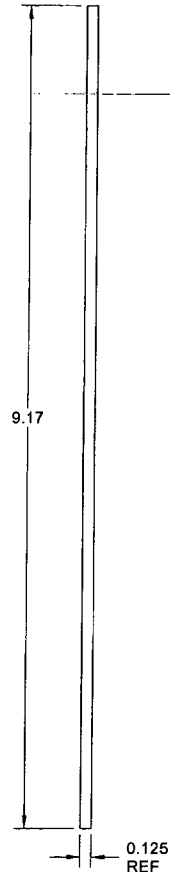
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

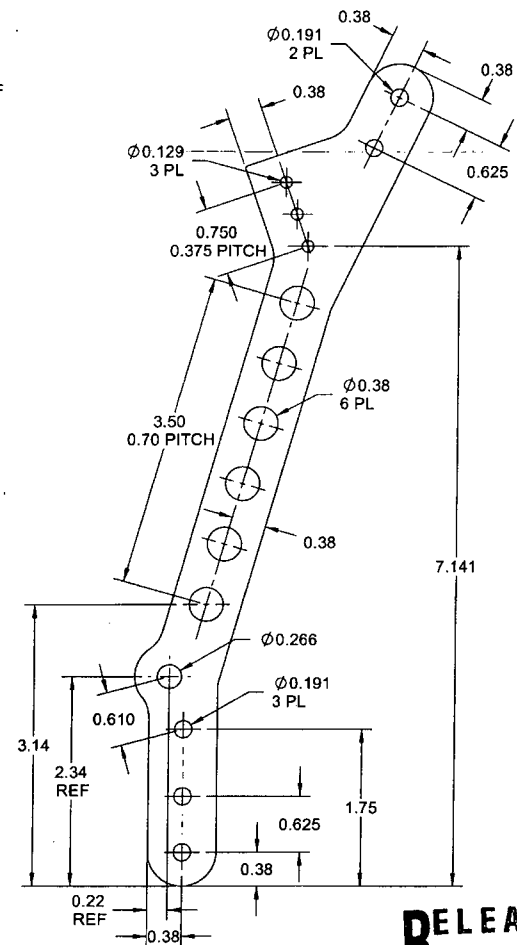
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76285



D3909-1 FWD X-TUBE LUG PLATE



(SUPPLEMENTAL VIEW)

- NOTES:**
- 1) MATERIAL: 303/304/316 STAINLESS STEEL 0.125" THICK SHEET ANNEALED 2B, PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240 PER DART SPEC M303S11GA OR M304S11GA
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.25 lbs

RELEASED
2010-08-01

DESIGN	JPH	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3909	SHEET 3 OF 5
APPROVED		TITLE	SCALE
DE APPR.		FWD X-TUBE LUG ASSY.	NTS
DATE	10.06.18	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES RE-COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

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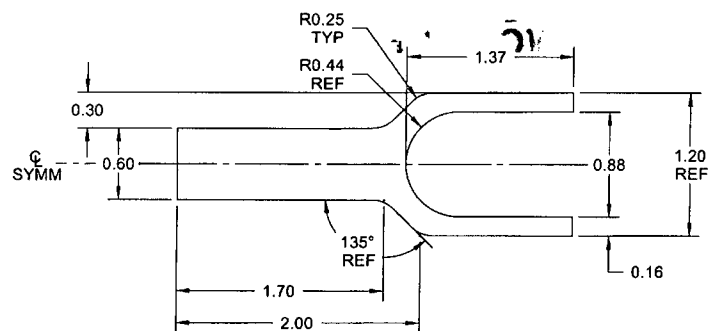
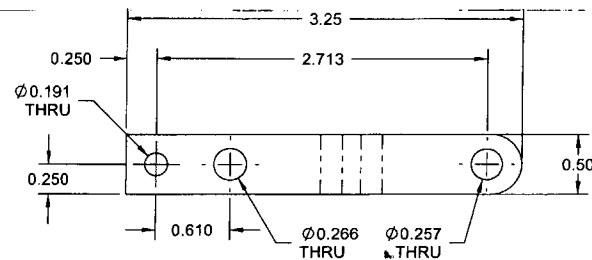
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

An isometric drawing of a mechanical component. It features a long rectangular base with two circular holes. A U-shaped bend is formed by two parallel plates that meet at a central point, creating a semi-circular opening. Each of these plates has a circular hole. Dashed lines indicate the hidden edges of the component.








D3909-3 FWD LOWER ATTACH ARM

RELEASED
2010-08-04

1) MATERIAL: 303/304/316 STAINLESS STEEL BAR, PER ASTM A582 OR ASTM A276
PER DART SPEC M303B OR M304B

- 2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: NONE
7) WEIGHT: 0.22 lbs

DESIGN	JPH	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3909	SHEET 4 OF 5
APPROVED		TITLE	SCALE
DE APPR: --		FWD X-TUBE LUG ASSY	NTS
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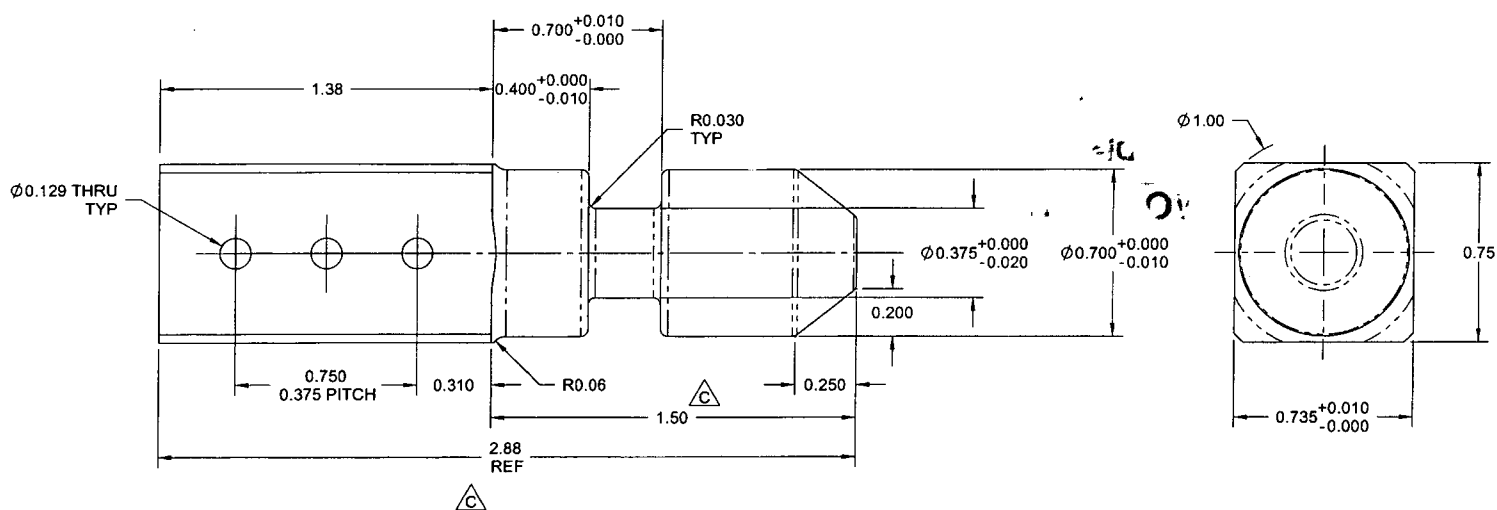
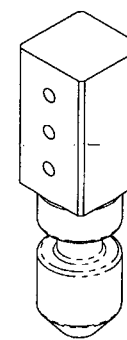
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76285



D3909-5 EYEBOLT STUD

RELEASED
2010-08-04

- NOTES:**
- 1) MATERIAL: 303/304/316 STAINLESS STEEL ROUND BAR PER ASTM A582 OR ASTM A276 PER DART SPEC M303R OR M304R
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3909-5" USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: 0.34 lbs

DESIGN	JPH	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3909	SHEET 5 OF 5
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DE APPR.		FWD X-TUBE LUG ASSY	NTS
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